

Date: Thursday, 13/11/2008 8:08:28 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 43404
Estimate Number : 11063
P.O. Number :
This Issue : 13/11/2008 **S.O. No.** :
Prsht Rev. : NC
First Issue : / / **Type** : SMALL / MED FAB
Previous Run : 42262
Written By :
Checked & Approved By :
Comment : Est A 00.06.06 New Issue EC
 Est Rev:B Now 6061-T6 06-06-23 JLM

Drawing Name : SADDLE SPACER
Part Number : D2935
Drawing Number : D2935 REV B
Project Number : N/A
Drawing Revision : B
Material :
Due Date : 20/11/2008 **Qty:** 20 **Um:** Each

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.0532 sf(s)/Unit Total : 1.0647 sf(s)

Material: M6061-T6 0.080" Thick

Batch 109784 B 8-11-13

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2935

Dwg Rev: B

Prog Rev: B

B 8-11-13

2-Deburr if necessary

B 8-11-13

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M/L 08/11/17

32 counted

32 X counted

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 13/11/2008 8:08:28 AM
User: Linda Lacelle

Process Sheet

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Drawing Name: SADDLE SPACER

Job Number: 43404

Part Number: D2935

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



90



counted

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-17

32

7.0

PACKAGING 1

PACKAGING RESOURCE #1



32x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 54

8/11/17

50

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/18

18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-11-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

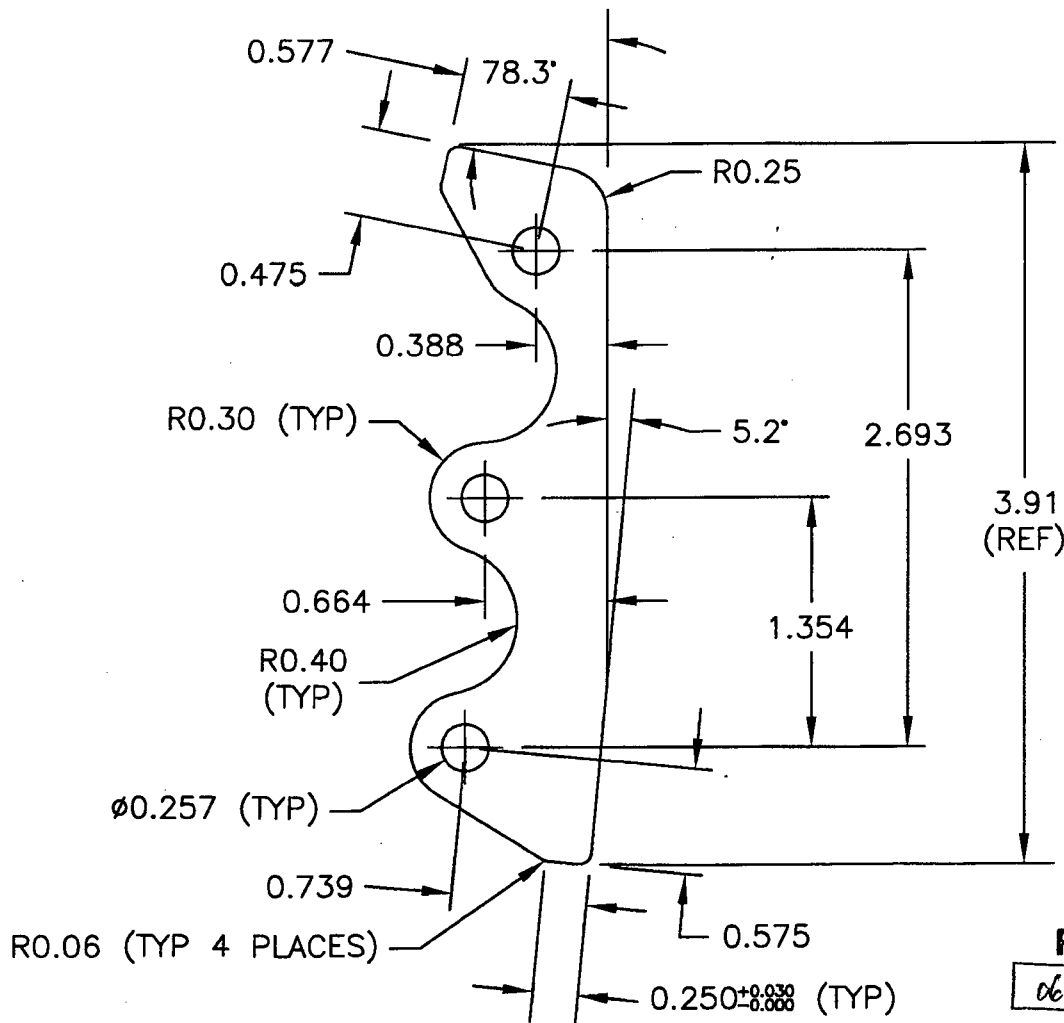
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN 77	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2935	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**RELEASED**

06.06.20 [Signature]

NOTES:

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 43404
Description: SADDLE SPACER	Part Number: D2935
Inspection Dwg: D2935, Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

x

[illegible]

Measured by:	RB	Audited by:	S	Prototype Approval:	N
Date:	8-11-13	Date:	08/11/14	Date:	A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	